

Work Order ID 71811

Tuesday, July 12, 2011 12:06:25 PM



Page 1

Item ID: D4017-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: mf

Date: 11-07-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4017

C

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: M117884 0.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4017 using DT9610B
inspect before welding mesh
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D4017
take lid to locate hinge and bracket

PC 11.07.18

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

11.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/11

0.00

Memo



125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

Memo

1 BK 11-9-20

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

GP 11/07/20 ①

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

GP 11/07/20 ①

170

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

w/o
7/808

GP 11/07/20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/20
mf
11-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 71811

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4017-1 Rib		Manufactured	No			100	Each	5.0000	1	1		7/11/07.19	
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	------------	--

Location	Loc Qty	Loc Code
WA006	5	
68394	2	
68481	3	

D4018-1 Rib		Manufactured	No				Each	4.0000	1	1		7/11/07.19	
----------------	--	--------------	----	--	--	--	------	--------	---	---	--	------------	--

Location	Loc Qty	Loc Code
WA	2	
687039	2	
WA005	2	
69077	2	

D4018-1 is the same as D4017-3

D4017-5 Hinge Rib		Manufactured	No			100	Each	6.0000	1	1		7/11/07.19	
----------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	------------	--

Location	Loc Qty	Loc Code
WA	6	
68480	2	
71106	4	

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 71811

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7

 Rib

Manufactured No

100 Each

4.0000

1 1



PL 11.07.19

Location

Loc Qty

Loc Code

WA

4

69730

1

71105

3

D4017-9

 Rib

Manufactured No

100 Each

6.0000

2 2



PL 11.07.19

Location

Loc Qty

Loc Code

WA

6

70341

6

D3916-041

 Rib Assembly

Manufactured No

100 Each

4.0000

2 2



PL 11.07.19

Location

Loc Qty

Loc Code

WA

4

69161

4

D3916-5

 Light Rib

Manufactured No

100 Each

15.0000

1 1



PL 11.07.19

Location

Loc Qty

Loc Code

WA

15

59088

5

69076

10

1

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Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 71811

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4034-041

Manufactured No

100

Each

3.0000

1



Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA006

3

69157

3

100

Each

2.0000

1

D4034-043

Manufactured No



Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA006

2

70241

2

100

Each

83.0000

2

D2581

Manufactured No



Mounting Bracket

Location

Loc Qty

Loc Code

WA

83

69258

28

69739

4

70766

51

100

Each

11.0000

1

D3913-15

Manufactured No



Wide Handle Plate

Location

Loc Qty

Loc Code

WA

8

69158

4

69647

4

WA005

3

69012

3

Pl 11.07.19

Pl 11.07.19

B71955 → ①

Pl 11.07.19

Pl 11.07.19

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Page 4

Work Order ID: 71811

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-1

Manufactured No

100 Each

25.0000

3

3



Hinge Half, Base



PL 11.07.19

Location

Loc Qty

Loc Code

WA

25

66418

0

68426

7

70342

18

3

D4020-3

Manufactured No

100 Each

0.0000

1



Mesh (350 Basket Short, Base)



B71814 -> 1 PL 11.07.19

D4020-11

Manufactured No

100 Each

6.0000

2

2



End Mesh, Basket



PL 11.07.19

Location

Loc Qty

Loc Code

WA

6

69648

6

B71725 -> 2

D4021-1

Manufactured No

100 Each

45.0000

3

3



Handle Plate



PL 11.07.19

Location

Loc Qty

Loc Code

WA

45

69518

8

69777

37

3

D2931

Manufactured No

150 Each

628.0000

2



Bumper



PL 11.07.20

Location

Loc Qty

Loc Code

ST504

628

46064

628

2

Tuesday, July 12, 2011 12:06:22 PM

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Page 4

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Page 5

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Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each

19.0000

2



Blanking Plate



2
7/21/07/20

Location

Loc Qty

Loc Code

GA

17

70349

17

WA005

2

67008

2

2

AN3-10A Purchased No

150 Each

160.0000

6



Bolt



6
7/21/07/20

Location

Loc Qty

Loc Code

ST351

160

117313

32

117795

128

6

~~AN960JD8~~ NAS1149DN832J Purchased No

150 Each

0.0000

2



Washer

48 M117316



2
7/21/07/20

MS20600-AD4W3 Purchased No

150 Each

893.0000

2



Cherry Rivets



2
7/21/07/20

Location

Loc Qty

Loc Code

ST321

760

111636

112

117505

494

117601

154

WA018

133

107939

133

2

Tuesday, July 12, 2011 12:06:22 PM

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Page 5

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Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,749.000

6

6



Nut

EBU/07/20

Location

Loc Qty

Loc Code

ST300

1749

116549

89

117441

800

117601

400

117885

460

6

NAS1149F0332P

Purchased

No

150

Each

170.0000

12

12



WASHER

EBU/07/20

Location

Loc Qty

Loc Code

ST275

170

117735

160

17317

10

12

Tuesday, July 12, 2011 12:06:23 PM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

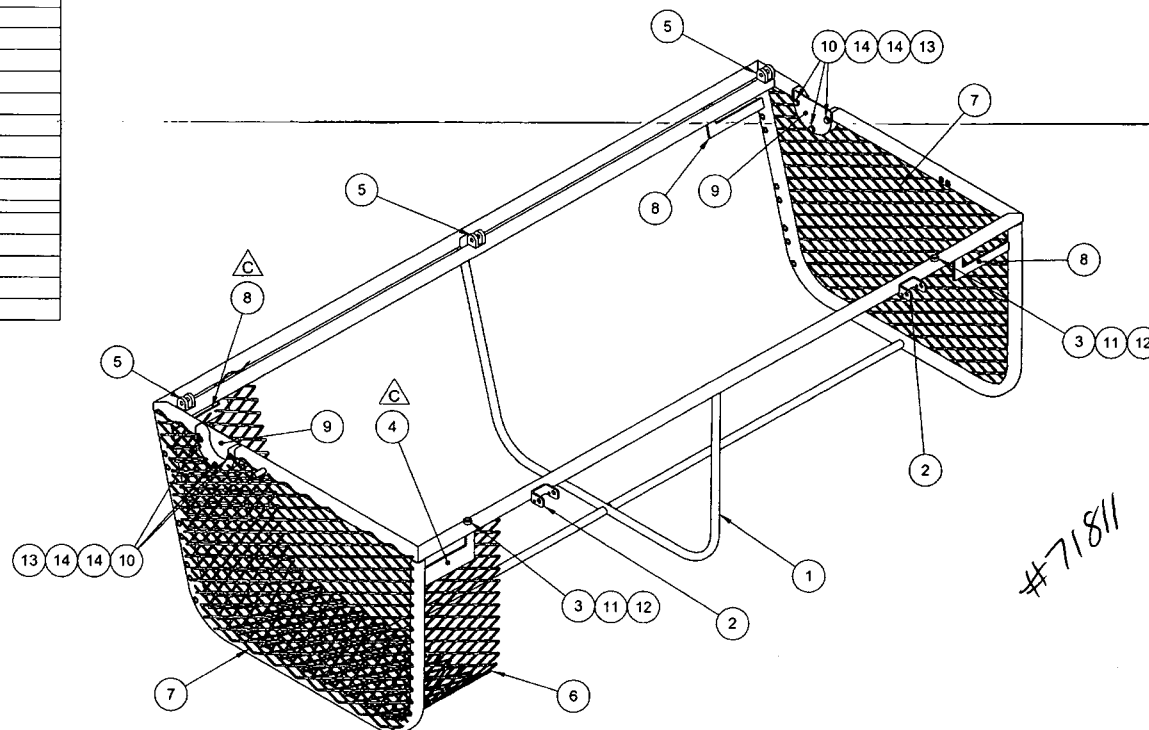
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596
RELEASED
10.08.12

NOTES:

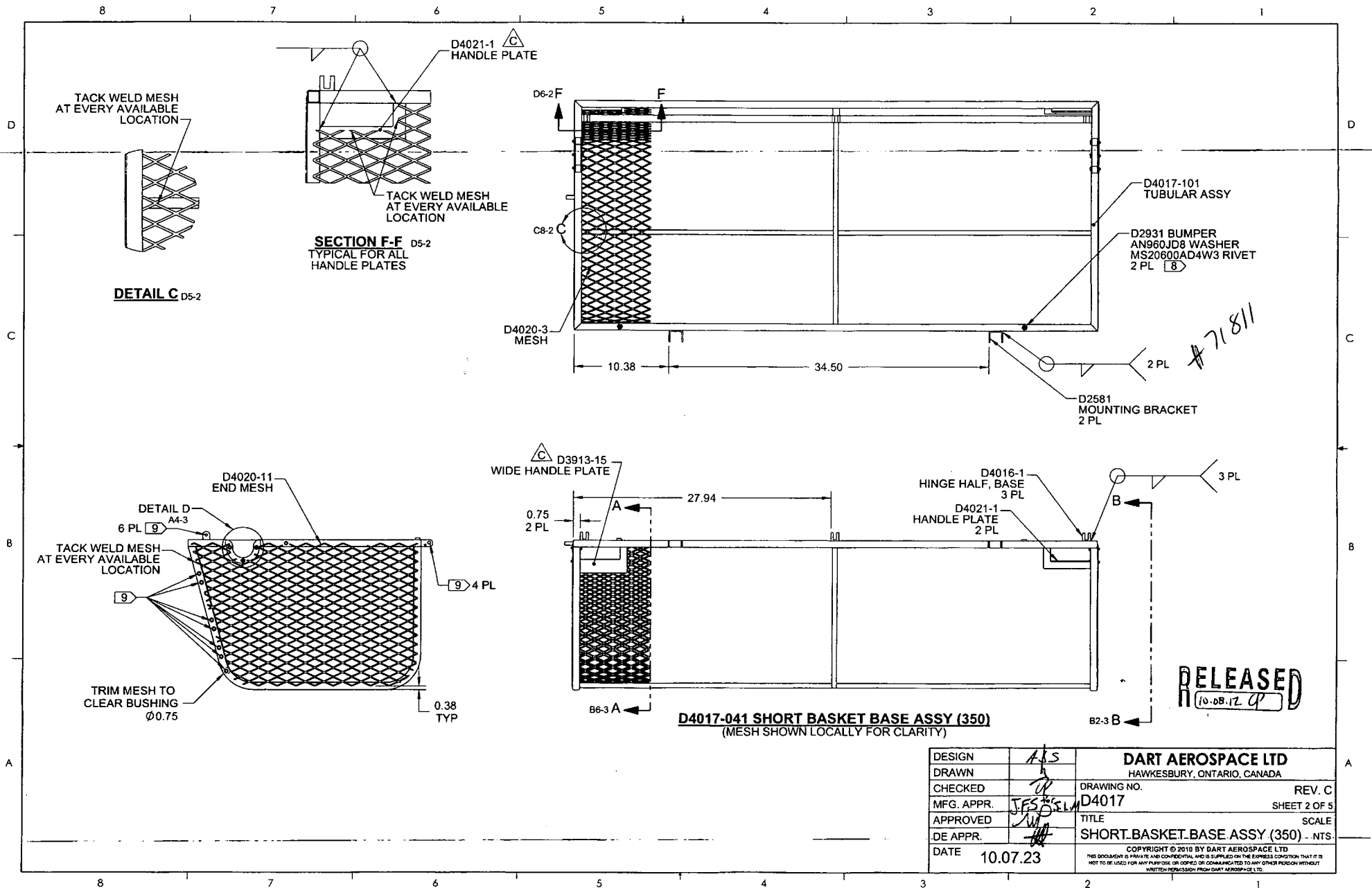
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED. DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	S.F.S.		
APPROVED	W		
DE APPR.	W		
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

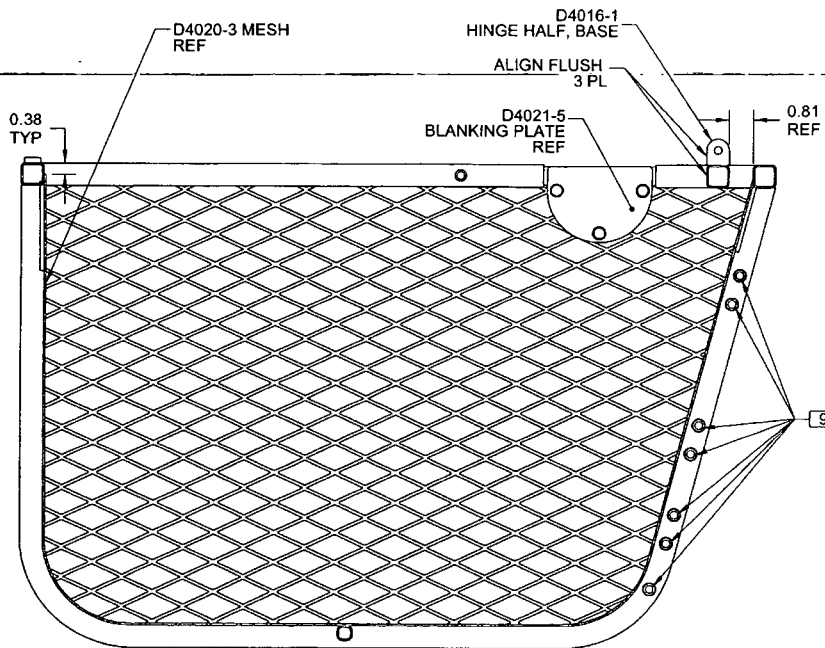
DRAWING NO. **D4017** REV. C
SHEET 1 OF 5
TITLE **SHORT BASKET BASE ASSY (350) _NTS**
SCALE

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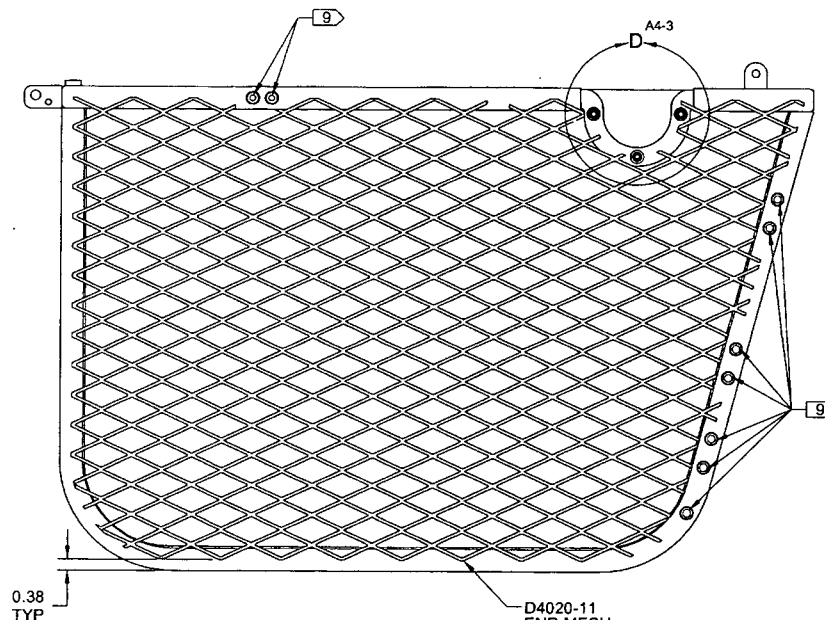


DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JES	D4017	SHEET 2 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	W	SHORT.BASKET.BASE ASSY (350) - NTS.	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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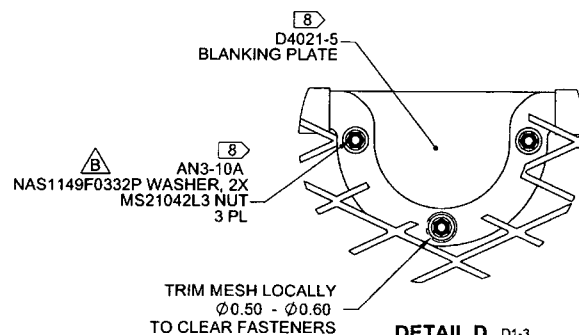
#71811



SECTION A-A A5-2



SECTION B-B A2-2

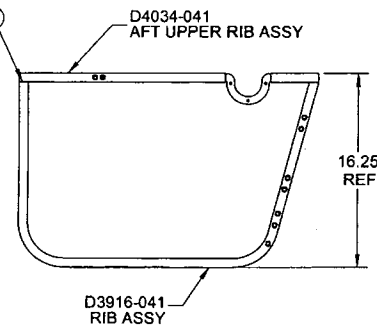
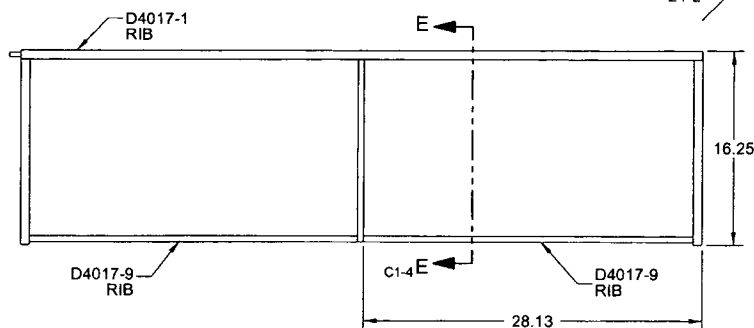
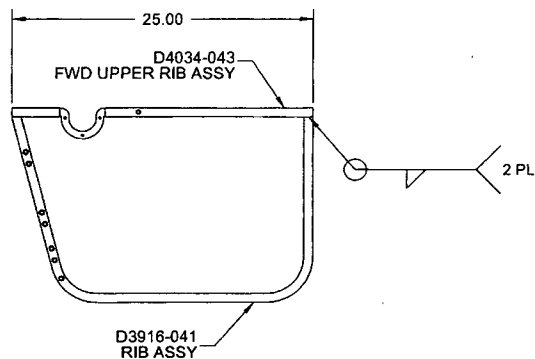
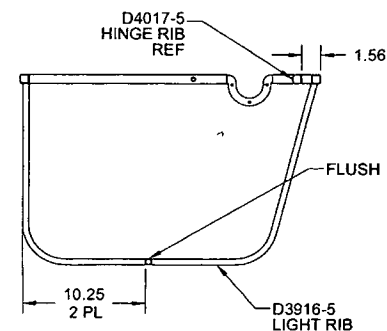
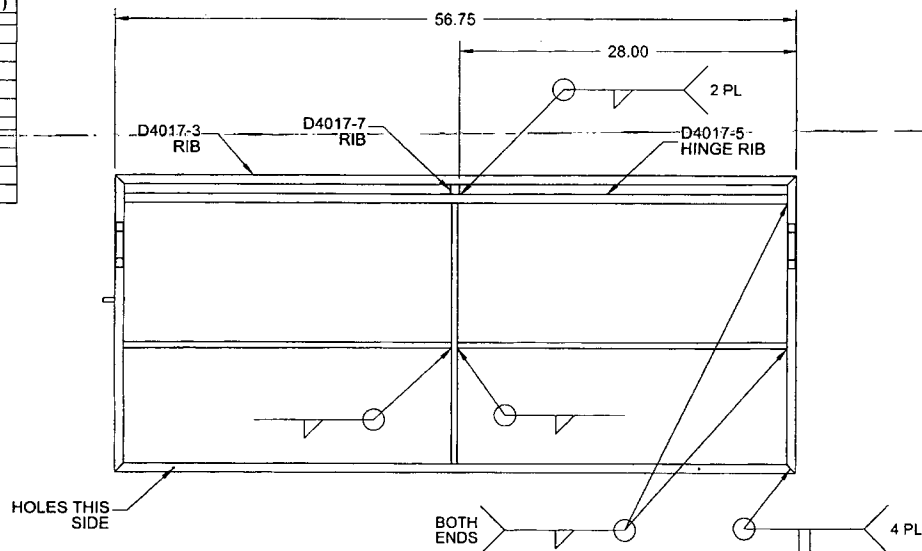


DETAIL D D1-3 B8-2

RELEASED
10.08.12

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JFS	DRAWING NO. D4017	REV. C
MFG. APPR.	JFS	SHEET 3 OF 5	
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	SHORT-BASKET-BASE ASSY (350) - NTS	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY

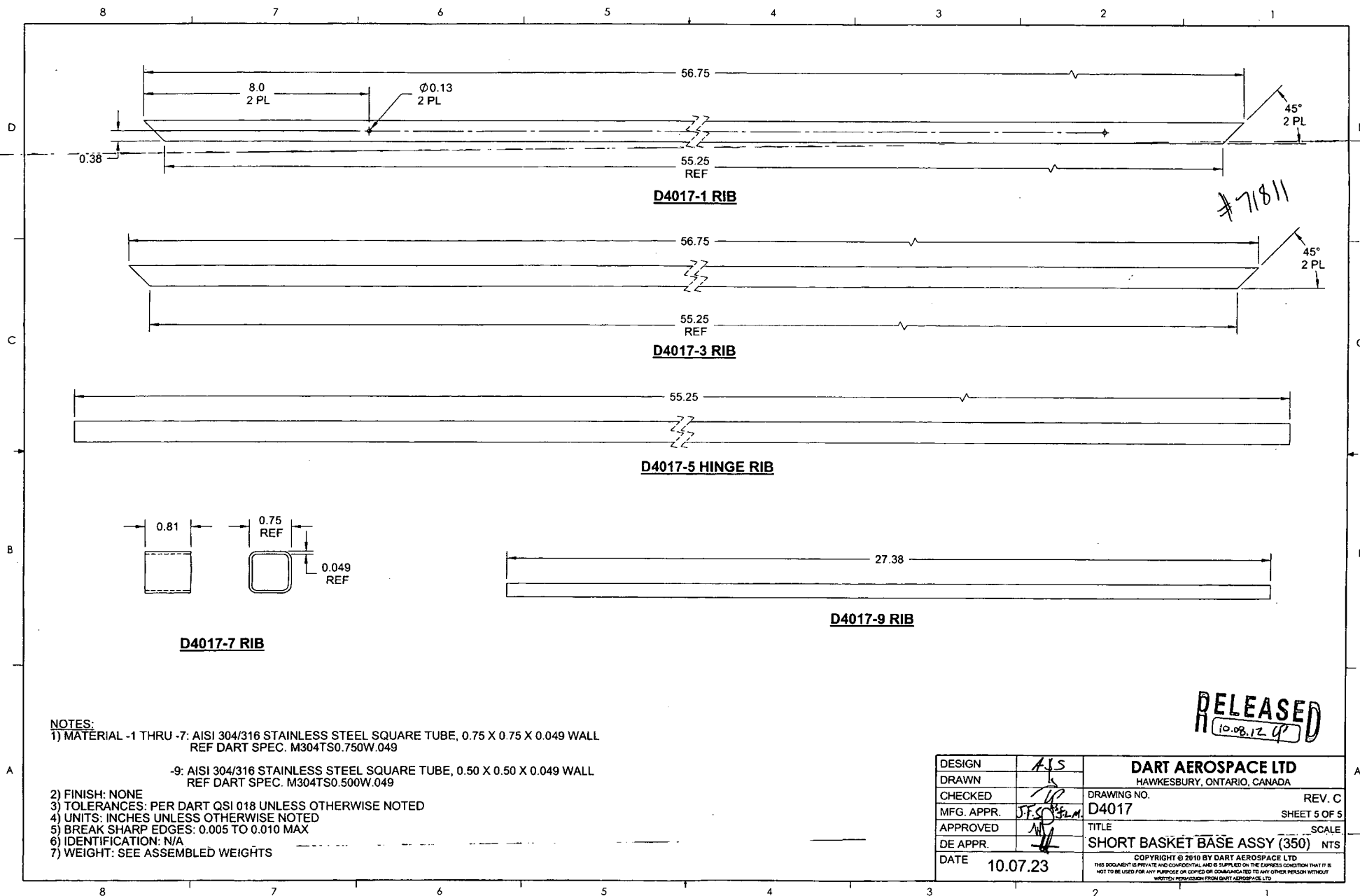


- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AKS	DRAWING NO.	REV. C
MFG. APPR.	SYS. ROL	D4017	SHEET 4 OF 5
APPROVED	JM	TITLE	SCALE
DE APPR.	JM	SHORT BASKET-BASE ASSY (350)	NTS
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RELEASED
10.08.12 CP



RELEASED
10.08.12 97

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO. D4017	REV. C
CHECKED	JP		
MFG. APPR.	J.F.S. J.L.M.		SHEET 5 OF 5
APPROVED	M	TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
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